

Work Order ID 164083

Thursday, July 13, 2017 11:47:39 AM

164083

Page 1

Item ID: D4785-117 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 7/12/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS Date: JUL 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4785	B								

100 0.00
100
 Large Fab Memo 1.74
 Large Fab 1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9922

2x DC 2017-07-24

105 QC6- All purchased or subcontracted products 0.00
105
 QC Memo 0.00
 Quality Control

2 DAS 38 9-89
JUL 25 2017

107 Weld per dwg A/R S.S. rod Batch: 138058 0.00
107
 Large Fab Memo 1.36
 Large Fab 1- weld bushing as per dwg D4785
 2- grind welds flush

2x 17-07-26

Work Order ID 164083

Thursday, July 13, 2017 11:47:39 AM

164083

Page 3

Item ID: D4785-117

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 7/12/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

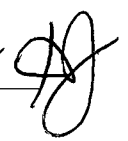
Memo

0.20

Quality Control



JUL 27 2017

17/12/28 

Picklist Print

Thursday, July 13, 2017 11:47:43 AM

Page 1

Work Order ID: 164083

164083

Parent Item: D4785-117

D4785-117

Parent Item Name: Rib Assembly

Start Date: 7/12/2017

Required Date: 7/20/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.06.21 DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4306-1		Manufactured	No			100	Each	3.0000	1	2			
D4306-1									**			<u>2017-07-24</u>	
Rib													

Location

Loc Qty

Loc Code

WA004

3

B146250 →

2

146250

2

146425

1

D4021-9		Manufactured	No			107	Each	46.0000	2	4			
D4021-9									**			<u>17-07-26</u>	
Bushing													

Location

Loc Qty

Loc Code

WA004

46

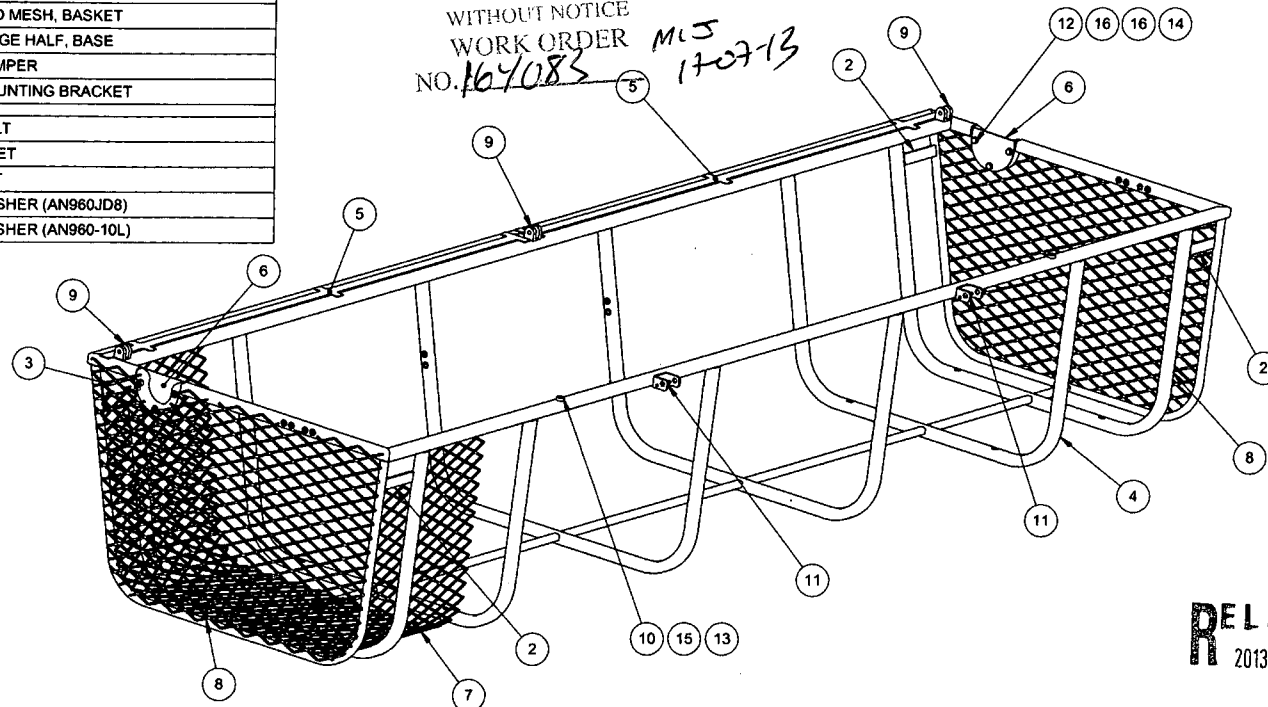
162060

46

B162060

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER *ML5*
NO. *167083* *17-07-13*



D4785-041 LONG BASKET BASE ASSY, LH/RH

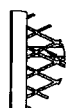
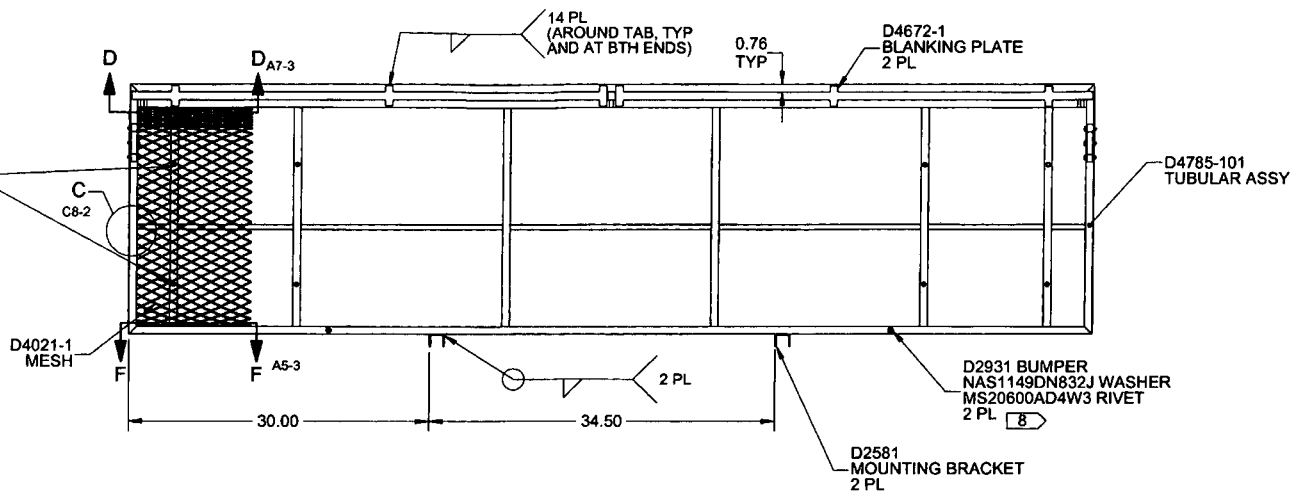
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2013-06-20

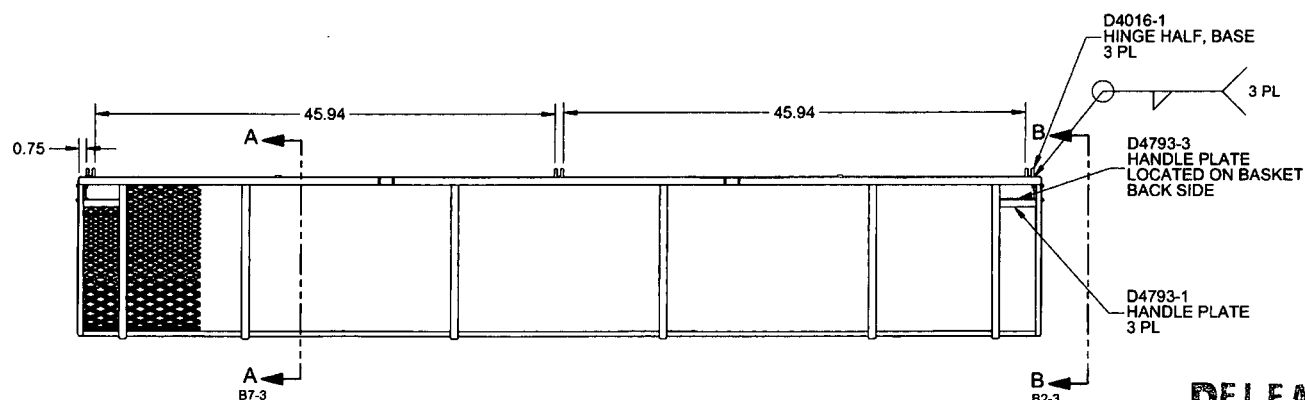
B	REPLACE D3918-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>SC</i>		
MFG. APPR.	<i>IS</i>		
APPROVED	<i>SC</i>		
DE APPR.	<i>SC</i>		
DATE	13.06.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4785 REV. B SHEET 1 OF 7 TITLE LONG BASKET BASE ASSY SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

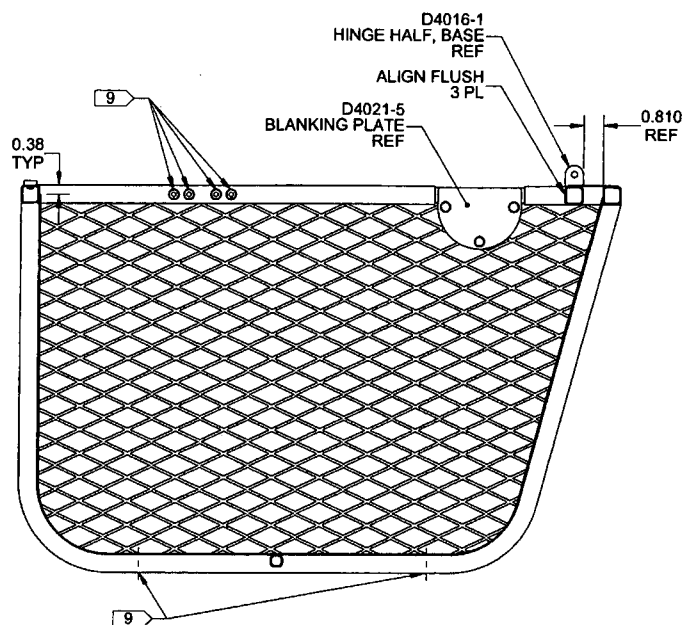
DETAIL C D7-2



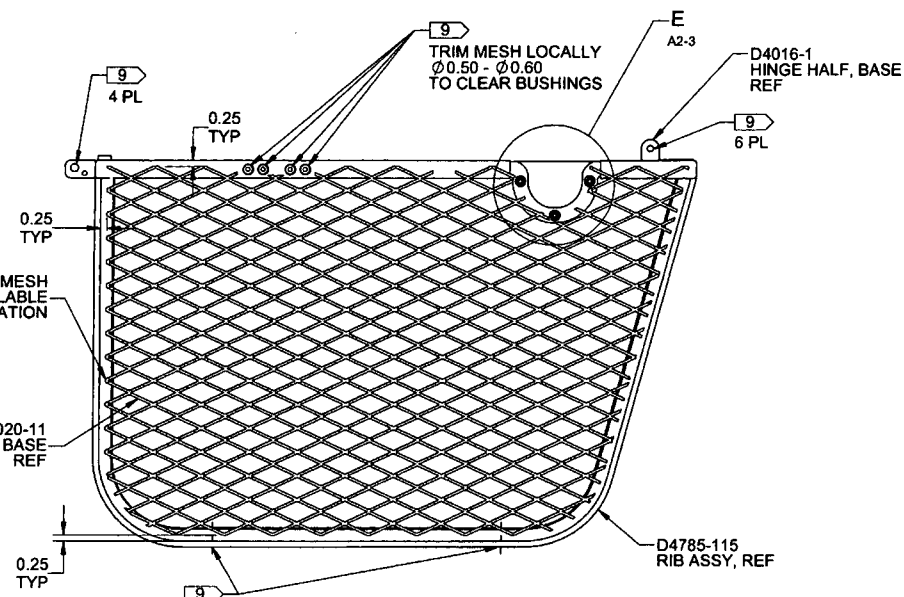
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

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2013-06-20

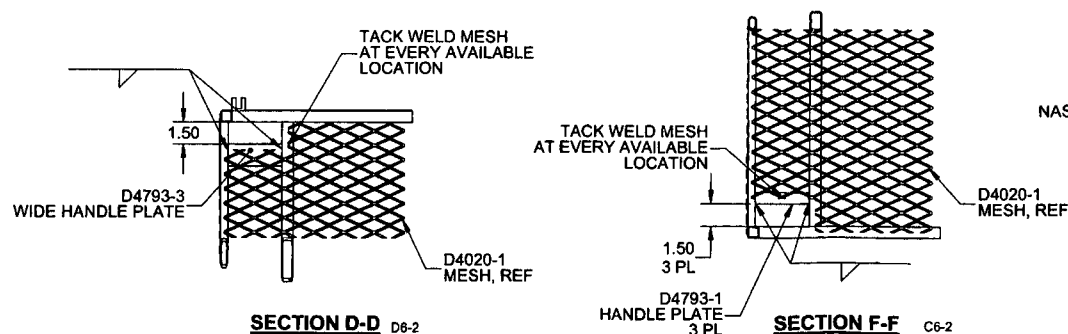
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>N</i>	D4785	SHEET 2 OF 7
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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SECTION A-A B7-2

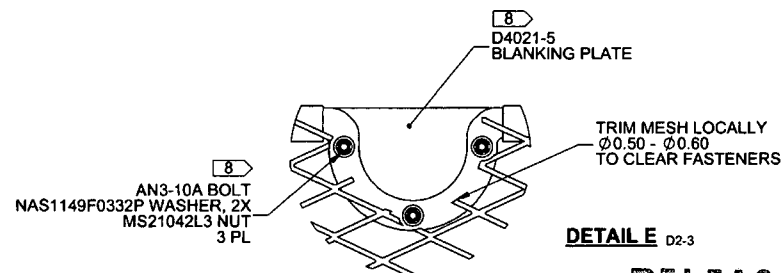


SECTION VIEW B-B A2-2



SECTION D-D D6-2

SECTION F-F C6-2
TYPICAL ON 3 PL

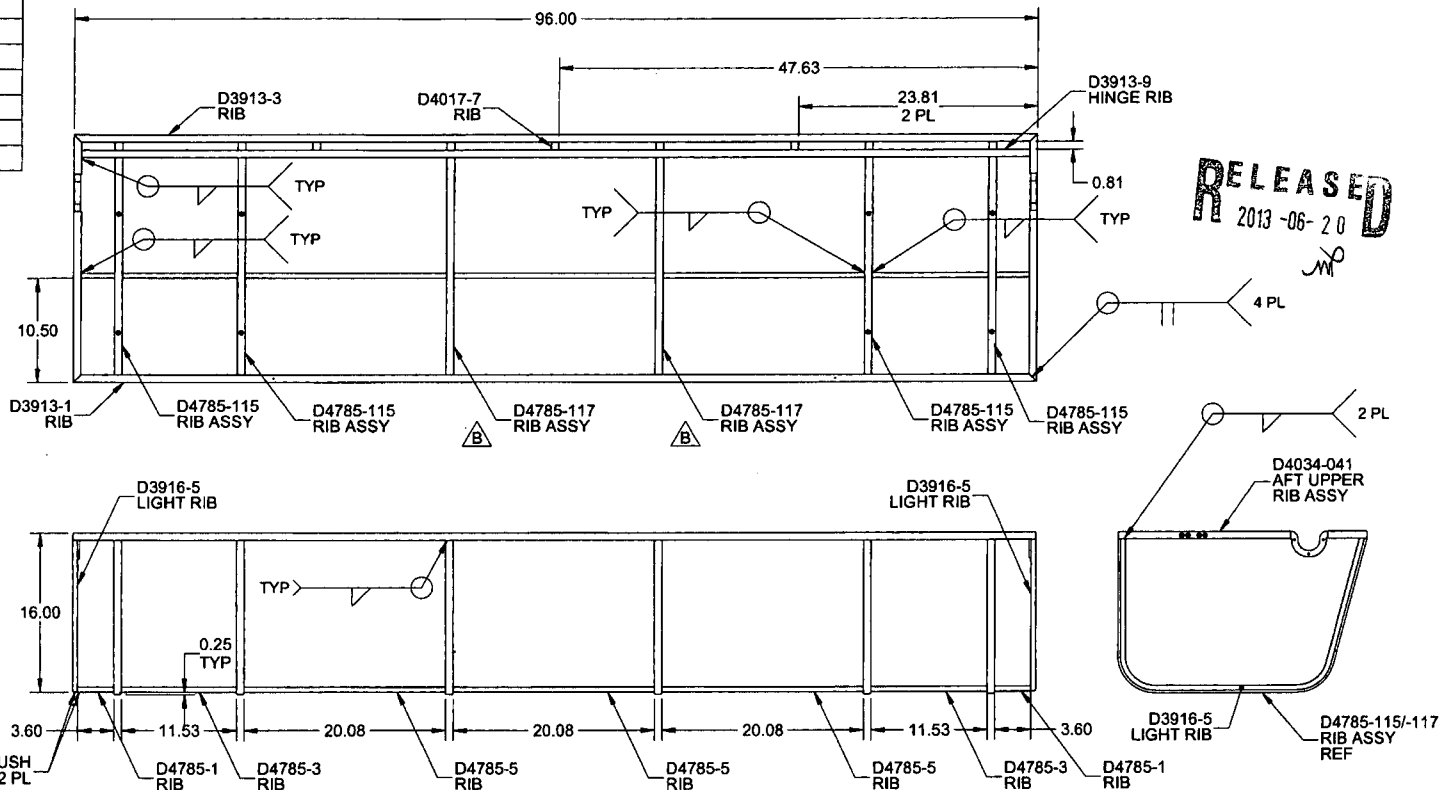


DETAIL E D2-3

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2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4785	SHEET 3 OF 7
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB

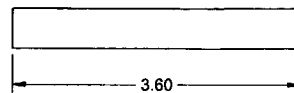


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2013-06-20

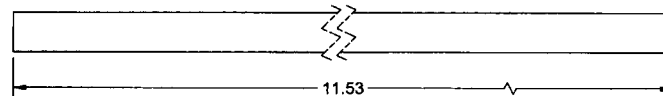
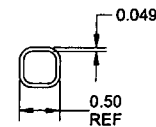
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 28.65 lbs
 - 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

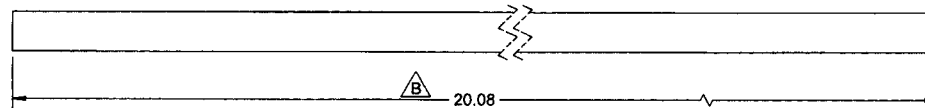
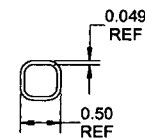
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4785	SHEET 4 OF 7
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	LONG BASKET BASE ASSY	NTS
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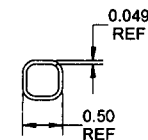
D4785-1 RIB



D4785-3 RIB



D4785-5 RIB



NOTES:

1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

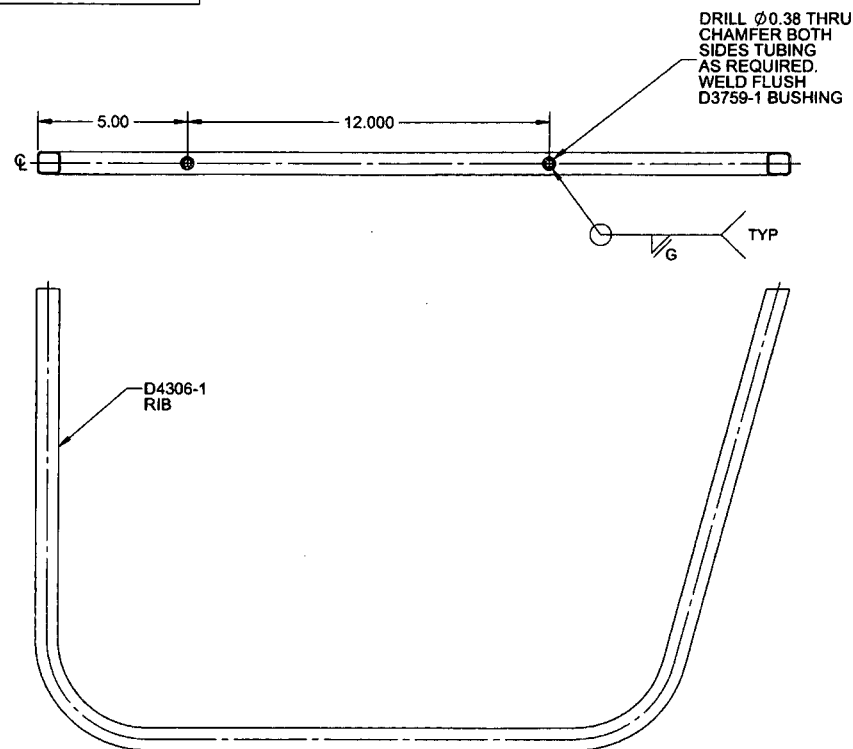
6) IDENTIFICATION: NONE

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2013-06-20
mt

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D4785	SHEET 5 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

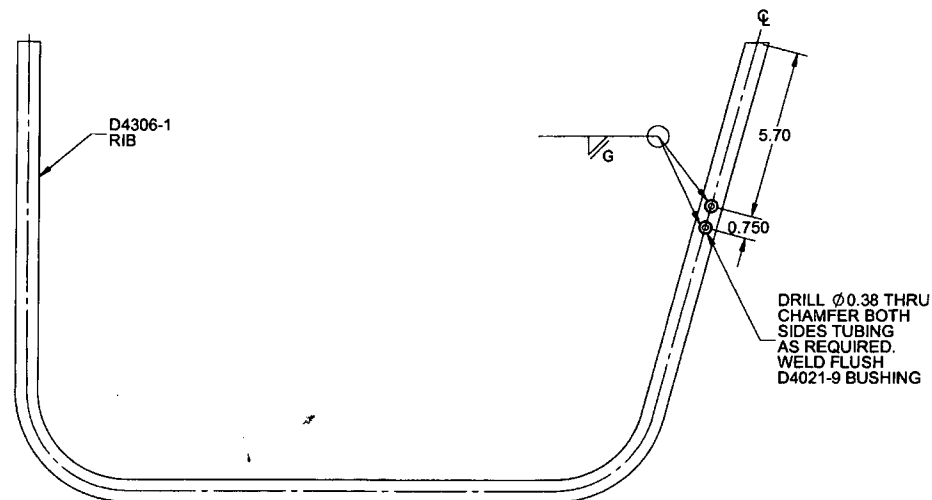
NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	XX	D4785	SHEET 6 OF 7
APPROVED	XX	TITLE	SCALE
DE APPR.	XX	LONG BASKET BASE ASSY	NTS
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2013-06-20
JW

ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

RELEASED
2013-06-20

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4785	REV. B
MFG. APPR.		SHEET 7 OF 7	
APPROVED		TITLE LONG BASKET BASE ASSY	SCALE NTS
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DATE	13.06.11		